VERSION WITH MARKINGS TO SHOW CHANGES MADE

4. (Amended) A can end according to [any of claims 1 to 3] claim 1 characterised in that an outer wall of the reinforcing bead in included to a line perpendicular to the central panel (26) of the can end at an angle between –15° and +15° and the height h: of the outer wall is up to 2.5mm.

5. (Amended) A can end according to [any of claims 1 to 4] claim 1 characterised in that the reinforcing bead has an inner portion parallel to an outer portion joined by said concave radius.

6. (Amended) A can end according to [any preceding] claim 1 characterised in that the ratio of the diameter of the central panel to the diameter of the peripheral curl is 80% or less.

7. (Amended) An can end according to [any preceding] claim 1 characterised in that it is made of a laminate of thermoplastic polymer film and a sheet aluminium alloy or tinplate or electrochrome coated steel.

9. (Amended) A method of forming a double seam between a can body (12) and a can end (22) [according to any preceding claim], said method comprising the steps of: -

placing [the] a curl (23) of the can end on a flange (11) of a can body supported on a base plate (4) ; locating a chuck (30) within the chuck wall (24) of the can end, said chuck having a frustoconical drive surface (32) of substantially equal slope B° to that of the chuck wall of the can end and a substantially cylindrical portion (33) extending away from the drive surface; causing relative motion and a first operation seaming roll (34) to form a first operation seam, and thereafter causing relative motion as between the first operation seam and second operation roll (38) to complete a double seam, during these seaming operations the chuck wall (24) of the can end becoming bent to contact the cylindrical portion (33) of the chuck.

An Abstract has been added